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D4956-23

Job Sheet 199511



Part No: D4956-23

Job Qty: 12 pcs

Part Name: Wearplate Center Fwd



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/27/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/13/19

Type: SOLD

Description:

Note: DWG REV A SHEETS 4,8 IPP REV:A 14.04.22 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Job Routing					Standard	Workcenter/Supplier		Sign-off
Op No	Operation	Qty	Start Date	Due Date	Setup Hrs	Run Hrs	Lead Time	
100	Waterjet - Flow - 1	12 pcs		9/13/19	0.17	3.32	Waterjet - Flow	JRB
120	QC 8	12 pcs		9/13/19	0.00	0.00	QC 8 - 12	
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	
QC 8 - 47								
QC 8 - 40								
QC 8 - 52								
QC 8 - 23								
QC 8 - 57								
130	Small Fab - Brake NC - B4B	12 pcs		9/13/19	0.25	0.54	Small Fab - Brake - 1 - B4B	DAS 30 9-59
							Small Fab - Brake - 2 - B4B	58 9-59
							Small Fab - Brake - 3 -	SEP 13 2019

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140 QC 5	12 pcs	9/13/19	0.00 0.00	B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150 Handfinish - 4-1-Assembly- B4B	12 pcs	9/13/19	0.00 1.16	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
160 QC 3	12 pcs	9/13/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
170 Packaging 3-1 - Stock - B4B	12	9/13/19	0.00 0.00	QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				Packaging 3 - 1 - B4B	

DAS

40

SEP 16 2019

9-89

R019-9-16

DAS

40

SEP 17 2019

9-89

pcs				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	FP-002
				Packaging 3 - 16 - B4B	201.00.00.17
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	12	9/13/19	0.00 0.00	QC 21 - SA - 21	68-8
pcs				QC 21 - SA - 70	12
				QC 21 - SA - 53	500

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Part Op 100 - (Waterjet - Flow)

Descriptions: 120 - (QC8- Inspect parts - second check)

130 - (Form as per dwg)

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Assemble as per dwg)

160 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location: _____)

180 - (QC21- Final Inspection - Work Order Release)

5217093

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S20GA	304/316 .040 Sheet	15 sf (1.25 ea)	100-Waterjet - Flow - 1	5200296

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S20GA	15	235	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	0.188Inches + 0.005 - 0.001	0.193 0.187	Diameter	
2	Wearshoe	0.300Inches ± 0.010	0.310 0.290		
3	Wearshoe	0.300Inches ± 0.010	0.310 0.290		
4	Wearshoe	1.885Inches ± 0.010	1.895 1.875		
5	Wearshoe	2.000Inches ± 0.010	2.010 1.990		
6	Wearshoe	6.750Inches ± 0.010	6.760 6.740		
7	Wearshoe	11.500Inches ± 0.010	11.510 11.490		
8	Wearshoe	16.750Inches ± 0.010	16.760 16.740		
9	Wearshoe	25.140Inches ± 0.010	25.150 25.130		
10	Wearshoe	30.530Inches ± 0.010	30.540 30.520		
11	Wearshoe	35.920Inches ± 0.010	35.930 35.910		
12	Wearshoe	41.310Inches ± 0.010	41.320 41.300		
13	Wearshoe	46.700Inches ± 0.010	46.710 46.690		
14	Wearshoe	50.200Inches ± 0.010	50.210 50.190		
15	Wearshoe	54.850Inches ± 0.010	54.860 54.840		
16	Wearshoe	56.850Inches ± 0.030	56.880 56.820		
17	Wearshoe	6.000Inches ± 0.030	6.030 5.970		
18	Wearshoe	14.000Inches ± 0.030	14.030 13.970		
19	Wearshoe	22.000Inches ± 0.030	22.030 21.970		
20	Wearshoe	30.000Inches ± 0.030	30.030 29.970		
21	Wearshoe	38.000Inches ± 0.030	38.030 37.970		
22	Wearshoe	45.000Inches ± 0.030	45.030 44.970		
23	Wearshoe	54.000Inches ± 0.030	54.030 53.970		

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



Route update only ☐

NCR No. _____

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube Machining Large Fab ☐ Cross tube Small Fab Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering Water Jet Supplier Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____	MRB (QSI042)				
Description Work Order Deviation			Disposition		Completed By		
					Lead hand / Supervisor		
					QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Undeclared Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐				